

METHOD FOR METALLURGICALLY JOINING
A TUBE TO A MEMBER

5 ABSTRACT OF THE DISCLOSURE

A method for metallurgically joining a tube to a member. A tube having a flange is obtained, and a member is obtained. The tube and the member are positioned with the flange contacting the member directly and/or indirectly through an intervening welding/brazing joining material. The flange and/or the member is segmented and their contact is a segmented contact at spaced-apart contact areas between the flange and the member. A resistance welding/brazing current path is created through the tube and the member at a first contact area creating a first weld/braze zone which includes at least some of the flange and at least some of the member. Then, a resistance welding /brazing current path is created through the tube and the member at a different second contact area creating a second weld/braze zone which includes at least some of the flange and at least some of the member.

10

15